

Date: Tuesday, 17/02/2009 10:18:13 AM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: MIRROR ARM		
Job Number	: 45811			Part Number	: D2010103		
Estimate Number	: 10505			Drawing Number	: D2010 REV D		
P.O. Number	:			Project Number	: N/A		
This Issue	: 17/02/2009	S.O. No.	:	Drawing Revision	: D		
Prsht Rev.	: NC			Material	:		
First Issue	: //	Type	: SMALL /MED FAB	Due Date	: 03/03/2009		Qty: 7
Previous Run	: 40667			Um:	Each		
Written By	:			KJ/RF			
Checked & Approved By	: JUD 09-02-17			Comment			
<p>Est : F 02.08.21 Re-format; Added D2057</p> <p>Est Rev:G 08-05-27 as per ECN1195P DD verified by:EC</p> <p>Est Rev:H 08-06-20 rev.D as per dwg DD verified by:EC</p>							

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	Barcode	Barcode	Comments
1.0	M304TR0500W049	304 RD Tube .500 x .049W			Comment: Qty.: 1.5750 f(s)/Unit Total : 9.4500 f(s) Material: 304/316 SS tubing 0.500" Dia. x 0.049" wall (M304TR0500W049) Batch No: M08824/3 M 08 823
2.0	BRAKE NC	NC BRAKE			Comment: BRAKE NC Punch per Dwg. D2010-103-T1 and Spec Control Dwg D2727 Identify as D2010-103
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1			Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Bend as per Dwg D2010 using bending Jig D2010-103T2 2- Deburr ends
4.0	D2057	Plug			Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Plug Pick: Qty Part Number Description Batch

1340048 M-1 04/04/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 45811		Part Number: D2010103
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		7X
Comment: SMALL & MEDIUM FAB RESOURCE 1		
1-flare before installing plug as per dwg D2010		
2-Install D2057 plug as per Dwg D2010		
6.0	QC5	INSPECT WORK TO CURRENT STEP
		S 09/04/13 X7
Comment: INSPECT WORK TO CURRENT STEP		
7.0	POWDER COATING	POWDER COATING
		7.
Comment: POWDER COATING		
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3		
START TIME: <u>11:50</u>		
OVEN TEMPERATURE: <u>360</u>		
FINISH TIME: <u>12:00</u>		
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		7
Comment: INSPECT POWDER COAT		
9.0	PACKAGING 1	PACKAGING RESOURCE #1
		7
Comment: PACKAGING RESOURCE #1		
Identify and Stock		
Location: <u>ST 22e</u>		
10.0	QC21	FINAL INSPECTION/W/O RELEASE
		7
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion		
		MF 09-04-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

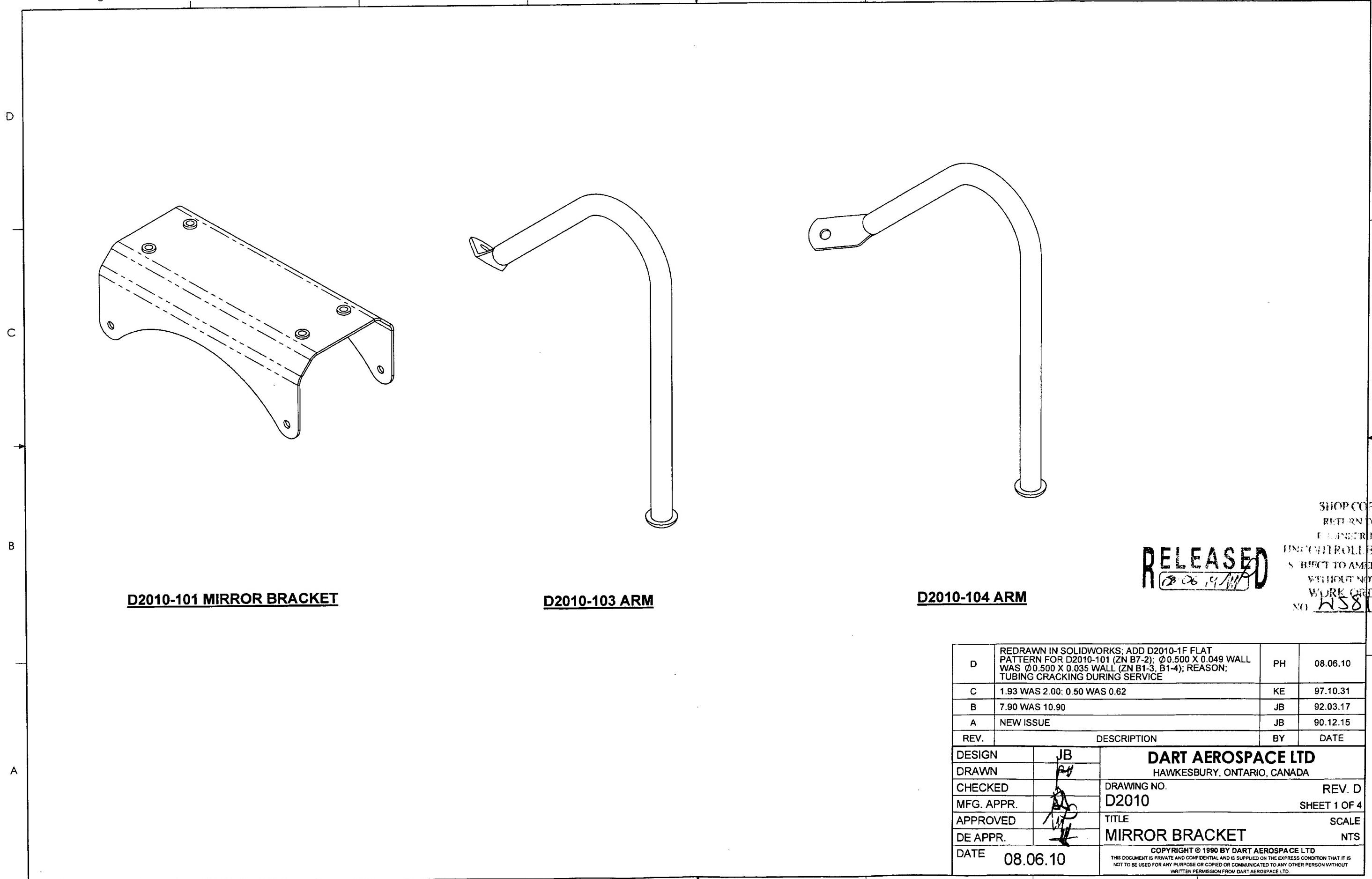
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D2010-101 MIRROR BRACKET

D2010-103 ARM

D2010-104 ARM

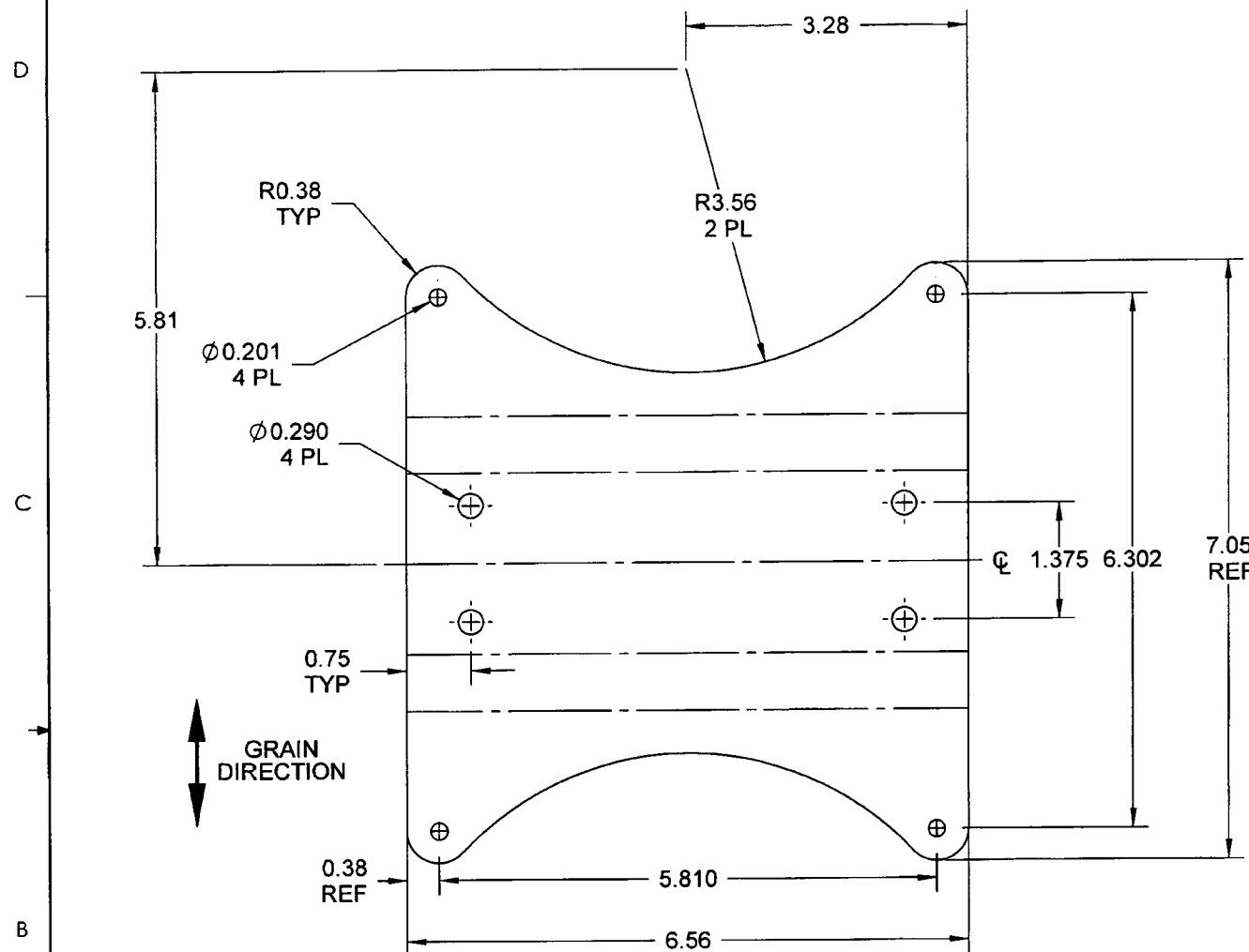
RELEASED
26/06/11

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO HS811

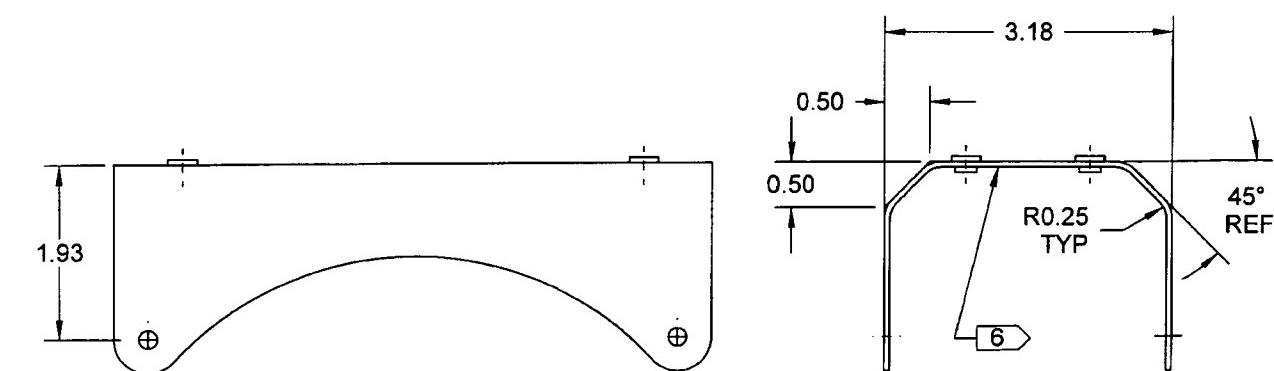
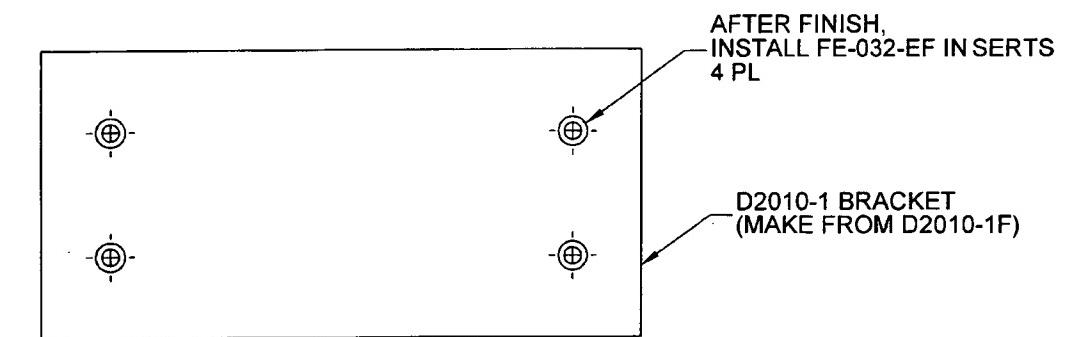
D	REDRAWN IN SOLIDWORKS; ADD D2010-1F FLAT PATTERN FOR D2010-101 (ZN B7-2); Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN B1-3, B1-4); REASON: TUBING CRACKING DURING SERVICE	PH	08.06.10
C	1.93 WAS 2.00; 0.50 WAS 0.62	KE	97.10.31
B	7.90 WAS 10.90	JB	92.03.17
A	NEW ISSUE	JB	90.12.15
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	AB	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.	AC	D2010	SHEET 1 OF 4
APPROVED	WP	TITLE	SCALE
DE APPR.	WV	MIRROR BRACKET	NTS
DATE	08.06.10	COPYRIGHT © 1990 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

QTY -101	P/N	DESCRIPTION
X	D2010-101	MIRROR BRACKET
1	D2010-1	BRACKET
4	FE-032-EF	INSERT



D2010-1F FLAT PATTERN



D2010-101 MIRROR BRACKET

RELEASED
28.06.1990
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 115811

SHOP COPY

RETURN TO

ENGINEERING

CONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 115811

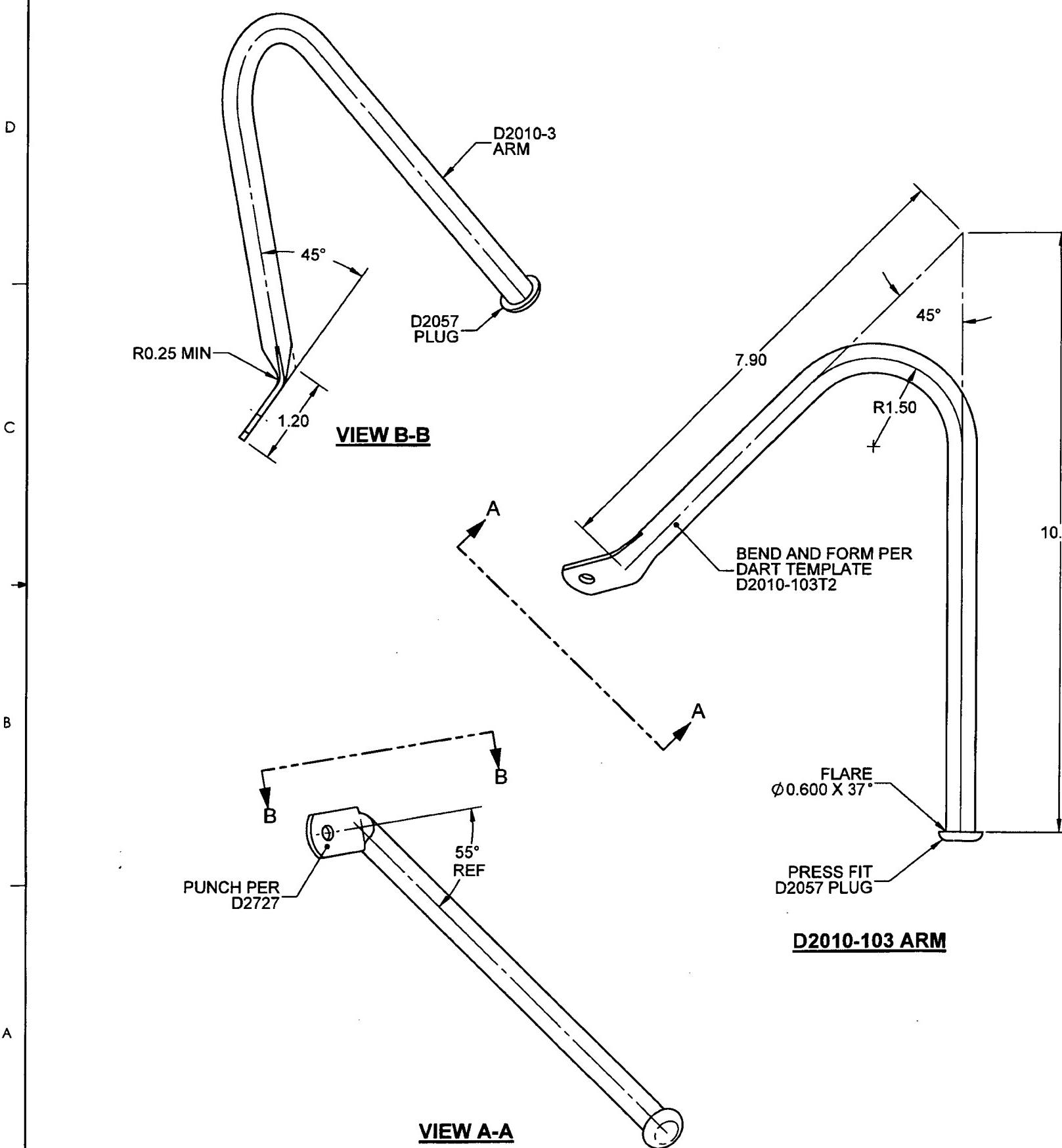
NOTES:

- 1) MATERIAL: D2010-1F: 2024-T3 ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-101" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
- 7) WEIGHT: 0.23 lbs

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	PF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		REV. D	
APPROVED		D2010	
DE APPR.		SHEET 2 OF 4	
DATE	08.06.10	TITLE	
		SCALE	
		NTS	
		MIRROR BRACKET	
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8 7 6 5 4 3 2 1

QTY -103	P/N	DESCRIPTION
X	D2010-103	ARM
1	D2010-3	ARM
1	D2057	PLUG



RELEASED
08.06.10 AM

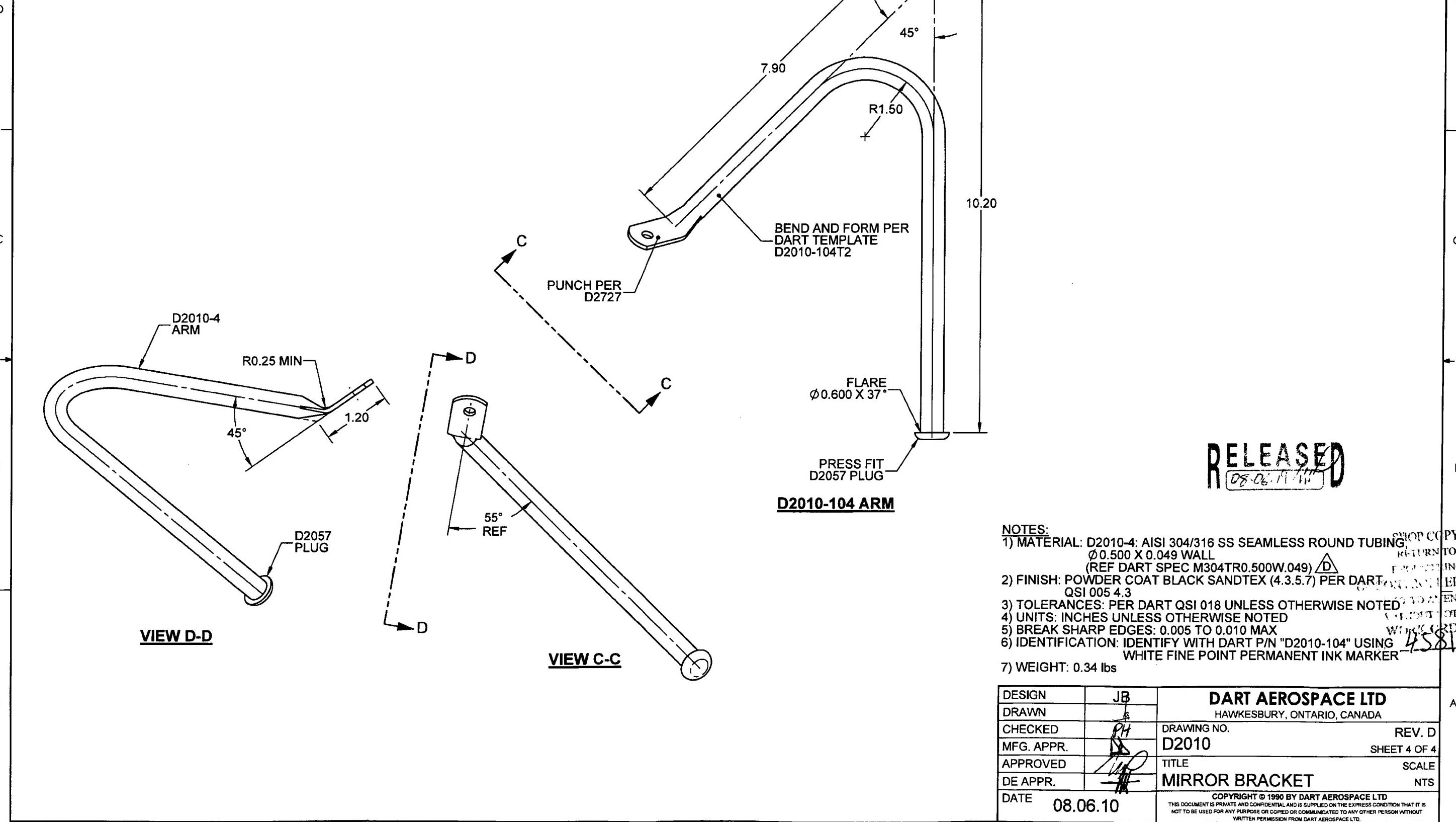
NOTES:

- 1) MATERIAL: D2010-3: AISI 304/316 SS SEAMLESS ROUND TUBING, Ø0.500 X 0.049 WALL (REF DART SPEC M304TR0.500W.049) SHOP COPY
BUTTING TO
ENGINEERING
CONTROLLED COPY
ATTACHMENT
NOTICE
ORDER
- 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3 DRAWING
ENGINEERING
CONTROLED COPY
ATTACHMENT
NOTICE
ORDER
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED CUT TO
ATTACHMENT
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED VOLUME
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX VOLUME
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-103" USING WHITE FINE POINT PERMANENT INK MARKER 45811
- 7) WEIGHT: 0.34 lbs

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	AB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	
MFG. APPR.	AB	D2010	
APPROVED	AB	REV. D	
DE APPR.	AB	SHEET 3 OF 4	
DATE	08.06.10	TITLE	
		SCALE	
		NTS	
		MIRROR BRACKET	
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8 7 6 5 4 3 2 1

QTY -104	P/N	DESCRIPTION
X	D2010-104	ARM
1	D2010-4	ARM
1	D2057	PLUG



8 7 6 5 4 3 2 1